Work Order ID Wednesday, June 08, 20								Shi	N F	Page 1
Item ID: D3211- Revision ID: PRELIM Item Name: Bracket			Accept				S	Setup Star		
Start Date: 6/9/201 Required Date: 6/10/20 Reference:				Cust Item II Customer:	D:	<u>_</u>	OREL MEL	INAIN/	IDY I	SSUE
Approvals: Proces QC:	s Plan: MMC	Date: \\- 0 @ - 08	Tooling: SPC (Y/N):	Da	te:		R	tun Stai Sto		
Sequence ID/ Work Center ID	Operation Description	·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3211	Revision Nbr									
Waterjet FLOW CNC Waterjet	FLOW WATER JET Memo 1-Cut as per Deburr if ne	Dwg D3211 □Dwg Rev cessary	0.00 . 0.00 . :Prog Rev:(38 [B11-	6-80 (4	$-\frac{5}{1}$) ss)
110 QC Quality Control	QC2- Inspect parts off m Memo	achine FAI/FAIB	0.00				-BH-	6-9 S	(cran	
QC Quality Control	QC8- Inspect parts - seco	nd check		ecto to PB		-11	rspeck	ly les	PB 1	·

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	Re	solution:	Dispositio	n:	_ QA: N/C C	losed:	•	Date: _	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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Page 2

Wednesday, June 08, 2011 8:07:23 AM D3211-1B Item ID: Accept Setup Start **Revision ID: PRELIM** Stop Bracket Item Name: Start Qty: 1.00 **Start Date:** 6/9/2011 **Cust Item ID:** Required Date: 6/10/2011 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Qty **Run Hours** Qty Code Number Stamp 130 0.00 Small Fab Small Fab 0.00 Memo Small Fab Debu 140 0.00 NC BRAKE Sp 11/04/09 Brake NC 0.00 Memo Brake NC Bend D3211-1 Stack as per Dwg D3211 150 QC5- Inspect part completeness to step on W/O 0.00 - inspatos 1 PB/ Memo

Quality Control

W/O:			V	VORK ORDER CHANGE	S				
DATE	STEP		PROCEDURE CH	IANGE	Ву	By Date Qty Approval Chief Eng / Prod Mgr			
		down							
-									
Part No	: <u>D3</u>	esolution: PAR #:		tegory: Juoil Hab:	NCR: Yes	lo DQA:	Date: _	11.00.21	
1000	R	esolution:			QA: N/C Clo		Date: _	11/06/2	
NCR: 70	1430		WORK OR	DER NON-CONFORMA	NCE (NCR)	# 212:			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
106.00	40	PART TRACKED ON F BEID.	1606.07	Scrap + Replace. Pake GT1 202 3.	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1		\$1.06.09 QS1642,	5.	
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				Lacinal remaining pro	ts South	11/06/10	1		
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Wednesday, June 08, 2011 8:07:23 AM

Item ID:

D3211-1B

Revision ID: PRELIM

Item Name:

Bracket

6/9/2011

QC:

Start Qty: 1.00

Accept

Setup Start

Stop

Start Date:

Required Date: 6/10/2011

Req'd Qty: 1.00

Date:

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Set Up/

Run Hours

Date: Date:

Run

Start Stop



Sequence ID/ **Work Center ID**

160

HandFinish Hand Finishing Operation Description

Chemical Conversion Coat per QSI005 4.1

Memo -

0.00

0.00

Tool ID

Tool # Plan

Accept Qty Code

Reject **Qty**

Reject Number

Insp. Stamp

170

Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

Memo START TIME:

0.00

180

Quality Control

QC3- Inspect Part Finish

0.00

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W/O:			W	ORK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Y	es N	o DQ	A:	Date:	
	R	esolution:	Disposition	n:	QA: N/C	Clos	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)				
DATE	OTED	Description of NC			tion B		Verification		Approval	Approval
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	-									

Work Order ID 70430

Wednesday, June 08, 2011 8:07:23 AM



Page 4

Item ID:

D3211-1B

Accept

Setup Start

Stop



Revision ID: Item Name: **Start Date:**

PRELIM Bracket

6/9/2011

Start Qty: 1.00 **Req'd Qty:** 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Run

Start



Required Date: 6/10/2011

QC:

Date: _____

SPC (Y/N):

Set Up/

Run Hours

Date:

Tool ID

Accept

Reject

Reject

Insp.

Sequence ID/ **Work Center ID**

190

Packaging

Memo

Operation

Description

Identify as per dwg & Stock Location:

0.00

0.00

Code

Tool # Plan

Qty

Qty

Number Stamp

Packaging

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 11/6/15 9X NF 11-06-14

POSITIVE RECALL

EFFECTIVE 11 DOA

RELEASED_

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W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cat	egory:	NCR: Yes	No DQ	A:	Date: _	
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DATE	STEP	Description of NC			on B	Verifi	cation	Approval	Approval
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' Picklist Print

Wednęsday, June 08, 2011 8:07:21 AM

Work Order ID: 70430

Parent Item: D3211-1B

Bracket Parent Item Name:



Start Date: 6/9/2011

Required Date: 6/10/2011

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP revA 11.06.07 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	271.0700	1.4		<u>311-6-8</u>		<u> </u>
				Location		Loc (<u>Oty</u>	Loc Code		į	图11-6-	10 G	י
				MAT022		27	1.07				_	(1)	\
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				1	17018	2	8.38			117012	_		
				1	17392	2	42.5		_	•••	_		

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W/O:			WC	RK ORDER CHANGE	S				
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Part No	•	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
	R	esolution:	Dispositio	າ:	QA: N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORMA	NCE (NCR))			
DATE		Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector
								3	
	<u> </u>								

DART AEROSPACE LTD	Work Order:	70430
Description: BLACKET	Part Number:	B37[1-1B
Inspection Dwg: D3d11-13, Rev: p81		Page 1 of 1

	FIRST	NARTICLE IN	SPECTIO	N CHE	CKLIST		
	×	First Artic	le X	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nents
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Measured by:	ik	Audited by:	6		Prototype A	pproval:	
Date:			M06/10			Date:	
·		to PBI Du	7			Pavisad by	Approved
Rev Date	Change New Issue		<u> </u>			Revised by KJ/JLM	Approved
Α	i New issue						

DART AEROSPACE LTD Work Order: 70430 Description: Beachet Part Number: D3211-1B (Bent) Inspection Dwg: D3211 Rev: PB1 Page 1 of 1 Bert

FIRST ARTICLE INSPECTION CHECKLIST

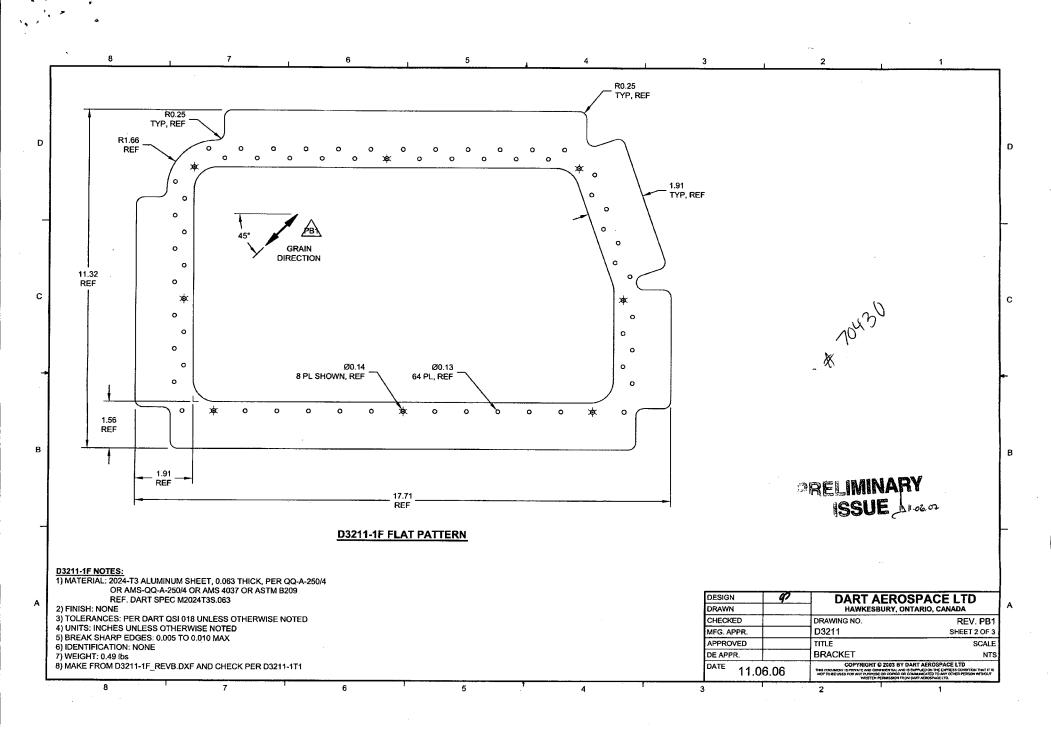
	X	First Artic	le _	Proto	otype
Drawing		Actual			NA - 41

	X	First Artic	le	Proto	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
9.504	± .030 *	9.50 4			TAPO MERC	N A14	25
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.650" 15.89"	2.030	15.875"			TAR WEAR	A147	5
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Rev Date	Change	TO PB	Day is	4	Re	vised by	Approved
A	New Issue				KJ	/JLM	

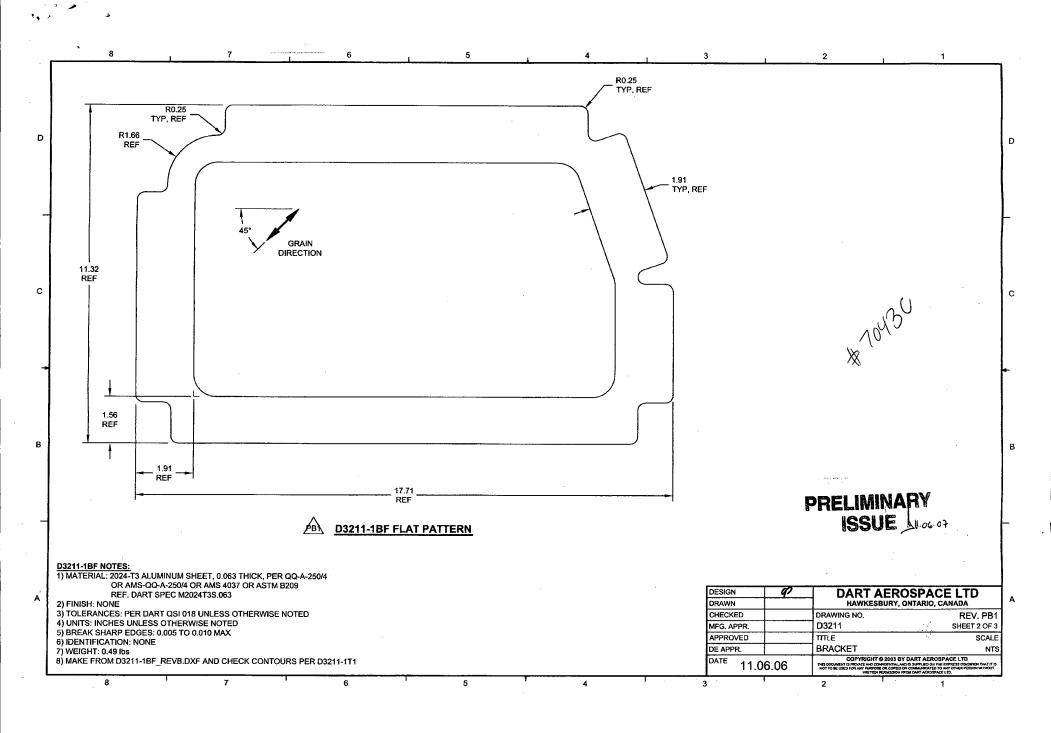
l	Rev	Date	Change	<u> </u>	Revised by	Approved
	Α		New Issue		KJ/JLM	

D o 9.50 O o 0 0 0 0 * 0 0 0 0 R0.125 BEND RADIUS 0.650 -PRELIMINARY ISSUE A 1.06.07 1.00 REF D3211-1 DOUBLER (MAKE FROM D3211-1F) (D3211-1B SIMILAR, MAKE FROM D3211-1BF) FORMAT TO NEW STD; INCORP. REV. A1 AND DEO; ADDED D3211-1/-18F. REASON: PAR11-109. 11.06.06 NEW ISSUE CP 03.09.03 Α REV. DESCRIPTION BY DATE D3213-1/-1B NOTES: DESIGN DART AEROSPACE LTD 1) MATERIAL: MAKE FROM D3211-1F OR D3211-1BF AS APPLICABLE 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 DRAWN HAWKESBURY, ONTARIO, CANADA POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3 CHECKED DRAWING NO. REV. PB1 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED MFG. APPR. D3211 SHEET 1 OF 3 4) UNITS: INCHES UNLESS OTHERWISE NOTED APPROVED TITLE SCALE 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX BRACKET DE APPR. 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" AND B/N "BXXXXX" PER QSI 044 6.1 7) WEIGHT: 0.49 lbs COPYRIGHT © 2003 BY DART AEROSPACE LTD DATE 11.06.06 8

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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date:	
Resolution:			Dispositi	_ QA: N/C	Closed:	Date:			
NCR:			WORK ORD	DER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verification		1 Approval	Approval
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DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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DATE	STEP	Description of NC	Corrective Action Section B		Veritic		cation Approval		Approval	
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W/O:			WC	RK ORDER CH	ANGES					
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Part No:		PAR #:	Fault Cate	gory:	NCF	l: Yes	Vo DQ	A:	Date:	
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DATE	STEP	Description of NC			Section B	VARIT		cation	Approval	Approval
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NOTE: Date & initial all entries

